

Work Order ID 57688

Tuesday, April 13, 2010 2:37:22 PM



Page 1

Item ID: D130-780-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacepod, LH

Start Date: 4/14/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/7/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: CMF

Date: 10-4-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D130-780

B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels per PPP D130-780-041 CHG 003

S 10/04/22

for CL 10/04/22

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-04-14

(P10)

Dart Aerospace Ltd

W/O: 57688		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-04-14	110	M52703-08 x1 add to pick kit M52703-08 x2 M52703-08 x2 NAS 1149 DN 8325 x2					
10-04-14	110	add to pick kit AN526C 832 R24 x4 B 110179	BT	10-04-14		<i>[Signature]</i> 10-04-14	<i>[Signature]</i> 10-04-14

Part No: D130-780-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00



Small Fab

Memo

0.00

25 10-04-19

Small Fab

1- Assemble as per dwg D3188,
2- use door to transfer drill hole location.
3- Remove foam core as per IIN- D350-600 figure 17a. Fill holes with Hysol
934NA with 10% milled fiber
A/R Hysol Batch: 113022
EXP: 10-09-16
A/R milled fibers Batch: 100859

130

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

S1064121



133

0.00



SprayPaint

Memo

0.00

25 10-04-20

Spray Painting

1- Prime as per Qsi 005
A/R primer Batch: 113582
A/R activator batch: 113582

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

135



QC

Quality Control

QC14- Inspect Spray Paint

0.00

S 10/04/21



Memo

0.00

137



Small Fab

Small Fab

Memo

1- Install hardware to spacepod ensure proper fit

0.00

0.00

S 10-04-21

138



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 10/04/21



Memo

0.00

Dart Aerospace Ltd

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Wing Walk as per dwg QSI005 4.4 Batch 113545

0.00



HandFinish

Memo

0.00

Hand Finishing

TOP SURFACE OF POD

85 10-04-21

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

106427(41)

160

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-4-27 SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

170



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

5 10/6/27

Memo

0.00

④

180



Packaging

Packaging

Memo
Identify and pack for shipping as per PPP D130-780-041
Location: 11C
PPP Rev: _____

0.00

0.00

10-4-27SP

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/6/28 MF

MF
10-4-28

Dart Aerospace Ltd

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10.03.29 add remove foam DD verified by:EC IPP Rev:D remove
D3188-1m add D3188-5 DD 10.04.07 verified by:JLM

Start Date: 4/14/2010

Required Date: 5/7/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS20426AD4-5		Purchased	No			110	Each	6,153.000	4.0000			
												
Rivet												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST317

6153

6733

1171

6874

4982

D2179

Manufactured

No

110

Each

61.0000

2.0000



Doubler

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST007

61

35432

61

D3188-5

Manufactured

No

110

Each

0.0000

1.0000



Spacepod Body

B 53067

4

ST 1004-14

x4

ST 10-04-14

x2

53067 ST 10-04-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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10.03.29 add remove foam DD verified by:EC IPP Rev:D remove
D3188-1m add D3188-5 DD 10.04.07 verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3538-1		Manufactured	No			110	Each	34.0000	2.0000			
Hinge Bracket											25 10-04-18	

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST069	34	
50336	2	
55012	12	
56092	8	
56531	12	

D3837-3



Decal

Manufactured No

110
#1606

20.0000 1.0000



10-4-27 SQ

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST092	20	
46232	9	
56380	11	

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Start Date: 4/14/2010

Required Date: 5/7/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21042L08		Purchased	No			110	Each	774.0000	4.0000			
												
Nut												

LT 10-04-14

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST300	400	
114330	400	
Main Warehouse		
ST301	374	
114056	174	
114227	200	

NAS1149DN832J

Purchased No



WASHER

110 Each

602.0000 4.0000

LT 10-04-14

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST275	394	
114340	394	
Main Warehouse		
ST297	8	
114108	8	
Main Warehouse		
ST298	200	
114348	200	

x4

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10.03.29 add remove foam DD verified by:EC IPP Rev:D remove
D3188-1m add D3188-5 DD 10.04.07 verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN3-10A		Purchased	No			160	Each	138.0000	2.0000			



Bolt

10-4-27 SD

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST351

138

111119

38

114330

100

Purchased No

160

Each

306.0000

4.0000

10-4-27 SD

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST350

306

113121

106

113359

200

Purchased No

160

Each

287.0000

4.0000

4
10-4-27 SD

AN3-6A



Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST351

287

113149

85

113288

2

113359

200

4

W/O:		WORK ORDER CHANGES					
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D3188-1m add D3188-5 DD 10.04.07 verified by:JLM

Start Date: 4/14/2010

Required Date: 5/7/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN525710R7		Purchased	No			160	Each	496.0000	38.0000			
Screw											10-4-27 SP	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST325

496

113288

196

113359

300

AN526C832R14

Purchased

No

160

Each

786.0000

2.0000

Screw

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST327

786

104916

786

AN525A

Purchased

No

160

Each

102.0000

41.0000

Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST337

102

110865

102

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10.03.29 add remove foam DD verified by:EC IPP Rev:D remove
D3188-1m add D3188-5 DD 10.04.07 verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3015-3		Manufactured	No			160	Each	126.0000	1.0000			
											10-4-27	SL
Locknut												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST033 126

43758 26

48238 4

56701 96

D3550-1		Manufactured	No			160	Each	25.0000	1.0000			
											10-4-27	SL
Strut												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST271 25

48367 15

56332 10

D3554-7		Manufactured	No			160	Each	45.0000	1.0000			
											10-4-27	SL
Ball Stud												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST070 45

37674 45

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Start Date: 4/14/2010

Required Date: 5/7/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3798-041		Manufactured	No			160	Each	5.0000	1.0000			
Spacepod Floor												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST241B

5

52802

1

53490

4

Manufactured No

160

Each

32.0000

2.0000

1

10-4-27 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST203

32

45729

1

46356

6

53469

13

56562

12

Manufactured No

160

Each

17.0000

3.0000

2

10-4-27 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST091

17

56523

17

2

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Required Date: 5/7/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3837-1		Manufactured	No			160	Each	18.0000	1.0000			
Decal											10-4-27 sf	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST092

18

46231

6

56382

12

Purchased No

160

Each

1,235.000 22.0000

10-4-27 sf

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST300

1235

113537

251

113644

984

Purchased No

160

Each

15.0000 10.0000

22

1114479 10-4-27 sf

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST302

15

113749

15

MS21042L3

Nut

Nut Plate

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Required Date: 5/7/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS24694-S54		Purchased	No			160	Each	190.0000	6.0000		10-4-27	Spl

Screw

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST289

190

113359

190

MS24694-S67

Purchased

No

160

Each

127.0000

7.0000

Screw

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST289A

127

111965

77

114341

50

MS24694-S69

Purchased

No

160

Each

107.0000

1.0000

Screw

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST289A

107

110153

7

112492

100

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 57688



Parent Item: D130-780-041



Parent Item Name: Spacepod, LH

Start Date: 4/14/2010

Required Date: 5/7/2010

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM IPP Rev:C
10.03.29 add remove foam DD verified by:EC IPP Rev:D remove
D3188-1m add D3188-5 DD 10.04.07 verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
NAS1149D0332J		Purchased	No			160	Each	519.0000	16.0000			



Washer

10-4-27 SP

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
FP	100	
113644	100	
Main Warehouse		
ST298	419	
112794	27	
113237	192	
114348	200	

NAS1149D0363J

Purchased

No

160

Each

1,898.0000 14.0000



Washer

10-4-27 SP

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST298	1898	
113288	42	
114292	1856	

14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 11

Tuesday, April 13, 2010 2:37:21 PM

Work Order ID: 57688

Parent Item: D130-780-041

Parent Item Name: Spacepod, LH

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM IPP Rev:C
10.03.29 add remove foam DD verified by:EC IPP Rev:D remove
D3188-1m add D3188-5 DD 10.04.07 verified by:JLM

Start Date: 4/14/2010

Required Date: 5/7/2010

Start Qty: 1.00

Required Qty: 1.00

Component-Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
NAS1149D0563J		Purchased	No			160	Each	1,909.000	3.0000			
Washer											10-4-2758	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST298

1909

113524

44

113706

1865

D130-780-043 Manufactured No

110

Each

0.0000

1.0000

Spacepod Door Assembly, LH CHC7002

B 57686

85 10-04-13

D3547-1 Manufactured No

160

Each

16.0000

1.0000

Bracket

10-4-2758

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST069

16

35455

2

50260

14

AKS4-1032-130 Purchased No

110

Each

0.0000

28.0000

Inserts

ALS4-1032-130

B 114407

85 10-04-21

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, April 13, 2010 2:37:22 PM

Work Order ID: 57688

Parent Item: D130-780-041

Parent Item Name: Spacepod, LH



Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM IPP Rev:C
10.03.29 add remove foam DD verified by:EC IPP Rev:D remove
D3188-1m add D3188-5 DD 10.04.07 verified by:JLM

Start Date: 4/14/2010

Required Date: 5/7/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D2237	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 110	Unit of Each	Qty on 55.0000	Remaining 2.0000	Qty	Date	Status
											RT 10-04-14	
Striker Plate												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST010

55

55006

6

55312

49

x2

A3235-020-935

Purchased

No

110

Each

596.0000

8.0000



Washer - Countersunk



RT 10-04-14

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST281

596

106150

596

Each

365.0000

1.0000

x8

MS21042L5

Purchased

No



Nut



10-4-27

SL

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST300

365

113523

26

113537

139

114108

200

1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 57688

Parent Item: D130-780-041

Parent Item Name: Spacepod, LH

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM IPP Rev:C
10.03.29 add remove foam DD verified by:EC IPP Rev:D remove
D3188-1m add D3188-5 DD 10.04.07 verified by:JLM

Start Date: 4/14/2010

Required Date: 5/7/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AKS4-1032-130		Purchased	No			160	Each	0.0000	10.0000			
Inserts												
D130-780-013		Manufactured	No			160	Each	7.0000	1.0000			
Switch Relocation												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FG122	7	
50272	1	
53079	4	
53483	1	
53905	1	

D130-780-011		Manufactured	No									
Aft LH Door Hinge												

1114407-10-4-27 SP
10-4-27 SP
57981 10-4-27 SP

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
X							D130-780-041	SPACEPOD™ LH, EC 130 B4
	X						D130-780-042	SPACEPOD™ RH, EC 130 B4
1		X					D130-780-043	DOOR ASSEMBLY, LH
	1		X				D130-780-044	DOOR ASSEMBLY, RH
1				X			D130-780-011	LH SLIDING DOOR HINGE KIT
1					X		D130-780-013	SWITCH RELOCATION KIT
				1		X	D130-780-015	CLOSEOUT KIT
2	2						D3815-041	WEB ASSEMBLY
3	3						D3815-5	PACKER
			1				D2589	"KEYS" KEY CHAIN
1	1						D3837-1	DECAL
1	1						D3015-3	LOCK NUT
		1					D3186-3	SPACEPOD™ DOOR, LH
			1				D3186-4	SPACEPOD™ DOOR, RH
1							D3798-041	FLOOR
	1						D3798-042	FLOOR
1							D3188-5	SPACEPOD™ BODY
	1						D3188-6	SPACEPOD™ BODY
1	1						D3547-1	BRACKET
0	1						D3550-1	STRUT
		1	1				D3552-7	GAS SPRING
1	1						D3554-7	BALL STUD
4	4						AN3-3A	BOLT
4	4						AN3-6A	BOLT
2	2						AN3-10A	BOLT
1	1						AN5-5A	BOLT
38	38						AN525-10R7	SCREW
8	8						AN526C832R14	SCREW
6	6						MS24694S54	SCREW
7	7						MS24694S67	SCREW
1	1						MS24694S69	SCREW
		2	2				MS27039-0811	SCREW
8	8						A3235-020-935	WASHER
14	14						NAS1149D0363J	WASHER
16	16						NAS1149D0332J	WASHER
		4	4				NAS1149DN832J	WASHER
3	3						NAS1149D0563J	WASHER
		2	2				NAS1515H3	NYLON WASHER
		2	2				MS21042L08	NUT
22	22						MS21042L3	NUT (or MS21042-3)
1	1						MS21042L5	NUT
10	10						AKS7-1032-130	INSERT
28**	28**						AKS7-1032-130	INSERT
10	10						MS21059L3	NUTPLATE

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Revision: B

Date: 09.06.11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
					2		D3819-1	MALE SPADE CONNECTOR
					2		D3597-1	FEMALE SPADE CONNECTOR
					1		D3598-2-096	EXPANDABLE SLEEVE
					24		D3599-1	TIE-WRAP
					24		D3600-1	TIE-WRAP MOUNT
					24		M22759/41-22-9	WIRE
					FT			
		1*	1*				D2464-1250	NEOPRENE SEAL
1**		1*					D3837-3	DECAL
	1**		1*				D3837-4	DECAL
		2*	2*				D2586	LATCH
		2*	2*				D2585	MOUNTING CHANNEL
		2*	2*				D2621	LATCH PLATE
		2*	2*				MS27039-1-15	SCREW
		2*	2*				NAS1149D0363J	WASHER
		2*	2*				MS21042L3	NUT (or MS21042-3)
		1*	1*				D2857-1	HINGE BRACKET
		1*	1*				D2857-2	HINGE BRACKET
		2*	2*				D2228	BACKING PLATE
		8*	8*				AN526C832R10	SCREW
		8*	8*				NAS1149DN832J	WASHER
		8*	8*				MS21042L08	NUT
		1*	1*				D3557-1	BRACKET
		2*	2*				D2228	BACKING PLATE
		1*	1*				D3554-7	BALL STUD
		1*	1*				NAS1149D0563J	WASHER
		1*	1*				D3015-3	LOCK NUT
		2*	2*				AN526C832R14	SCREW
		2*	2*				AN526C832R10	SCREW
		4*	4*				NAS1149DN832J	WASHER
		4*	4*				MS21042L08	NUT
2**	2**						D2237	STRIKER PLATE
4**	4**						MS20426AD4-5	RIVET
2**	2**						D3538-1	HINGE BRACKET
2**	2**						D2179	HINGE BRACKET PLATE
4**	4**						AN526C832R24	SCREW
4**	4**						NAS1149DN832J	WASHER
4**	4**						MS21042L08	NUT
				1			D3813-041	HINGE ASSEMBLY, UPPER DOOR
				1			D3813-043	HINGE ASSEMBLY, LOWER DOOR
				2***			D3518-3	ROD END

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Revision: 5

Date: 09.06.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD.

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-041	-042	-043	-044	-011	-013	-015	Part Number	Description
				2***			NAS509-6	NUT
				1			D3814-1	HINGE, UPPER AIRFRAME
				1			D3814-3	HINGE, LOWER AIRFRAME
				2			D3816-1	SPACER
				4			D3816-3	SPACER
				1			D3817-041	ANCHOR PLATE
				2			AN3-5A	BOLT
				3			AN3-7A	BOLT
				2			AN310-4	CASTLE NUT
				2			AN4-17	BOLT
				2			AN970-4	WASHER
				5			MS21042L3	NUT
				2			MS24665-212	COTTER PIN
				3			MS24694S46	SCREW
				8			NAS1149D0363J	WASHER
				2			NAS1149D0463J	WASHER
				1			D3552-7	GAS SPRING
				2			D3622-1	BALL STUD
				1			D3820-1	DOOR SUPPORT
				2			MS21042L5	NUT
				2			NAS1149D0563J	WASHER
				1			D3892-1	SEAL
						1	D3983-1	OUTER CLOSEOUT
						1	D3983-3	INNER CLOSEOUT
						1	D3983-5	HINGE CLOSEOUT
						1	D3983-047	CLOSEOUT ATTACHMENT
						1	D3983-9	SPACER
						2	AN525-10R6	SCREW
						1	AN525-10R24	SCREW
						1	NAS1149D0363J	WASHER
						1	MS21042L3	NUT

* Pre-installed on D3186-3/-4 Spacepod™ Door

** Pre-installed on D3188-5/-6 Spacepod™

*** Pre-installed on D3813-041/-043 Hinge Assemblies

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries